Page 1

104875

July-22-13 2:21:29 PM

Quality Control

Item ID: D2221 Accept *N900040100* Setup Start Revision ID: Basket Base Assembly Item Name: Start Date: 7/22/13 Start Oty: 1.00 **Cust Item ID:** Required Date: 8/05/13 Reg'd Oty: 1.00 Customer: Reference: Run Process Plan: ______ Date: 13-07-77 Tooling: Approvals: Date: Stop SPC (Y/N): Date: Date: Operation Sequence 1D/ Tool ID Set Up/ Tool# Plan Accept Reject Reject Work Center ID Description Run Hours Qty Code Qty Number Stamp Draw Nbr Revision Nbr D2221 Rev H 100 0.00 CC 13-8-7 Large Fab *100* Large Fab 0.00 Large Fab 1- assemble all ribs and both D2581 in DT9444 jig. weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D222 A/R ER316 S.S. Rod Batch: 13 ***PLEASE NOTE SEE DWG*** IF MAKING -141/-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER DWG 110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 1 2/ /3-8-8 *110* OC 0.00Memo

											DQA:	Dat	e:
NCR: Ye	es /	No				WORK ORDER NON-	O	NFOR!\	MANCE / UPDAT		QA Closed:	Dat	e:
						DISPOSITION				AGAINST DEI			<u>. </u>
Work Order Part No	o					Rework Scrap Use-as-is Work Order Update		Therm	Machining S noforming	Finishing omposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			Ĭ		Descrip	otion of work order update	ı	initial	Action		Sign &		
Cause	D	ate	Step	Qty	C	r Non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
						F	AUL	T CATE	SORY				
Landin	Ben Cen	tre Not	Concen	ntric to O	/s	General Bend BOM/Route Broken/Damaged		Grain Hardwa Inspecti	re on Incomplete		Ovalized Over/Under Part Incorred	⊢	Pressure/Forced Temperature/Cure Weld
Crushed/Crimped Cuffs Heat Treat				Burrs Contamination Countersink		Instructions Incomplete/Unclear Maintenance Mislabeled			Part Lost/Mi Part Moved Positioned V		Wrong Stock Pulled		
Inspection Strip in Tube				Cut Too Short Drill Holes		Misread Offset			Power Loss/	Surge	Other		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 104875

July-22-13 2:21:29 PM

104875

Item ID: Revision ID:	D2221				Accept	*N900	040100)* s	setup Star	*N	S1*
Item Name:	Basket Base A	ssembly			ļ				Sto	^p *N	S2*
Start Date: Required Date:	7/22/13 8/05/13	Start Qty: 1.00 Req'd Qty: 1.00		:1* :1*	i	Cust Item I Customer:	D:			7.0	
Reference:								•	S4	.4 .	
Approvals:	Process Pla QC:	on:	Date:		Tooling: SPC (Y/N):	Da	ate:	k	tun Star Sto	171	R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC6-Inspect dimensions	s to drawing		Set Up/ Run Hours 0.00	Tool ID	Tool# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS
120 QC Quality Control		Memo			0.00				13-03	<i>0</i> 3	09
125 *125*		Pressure Wash per QSI00	05 4.3		0.00			.1	PB	J3 ^{7. 9}	38
HandFinish Hand Finishing		Memo			0.00				<u>" /</u>	_/	· · · ·

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		QA Closed:		ıte:	,
						DISPOSITION				AGAINST	DE	PARTMENT		-	··· —···
Work Ord	er:						_			-	_			_	
Part I	No.					Rework Scrap Use-as-is	 	r	Skid-tube Machining noforming	Crosstube Small Fab Finishing	_	-	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR i	No.					Work Order Update]		Large Fab	Composite	_		Supplier	_	
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling							1							ļ	1
Operator															
Material															-
Setup	П														
Other	П														
Process	П		1				1								
Supplier				[}	
Training	П													İ	1
Unapproved	П														
		·				F	AUI	LT CATE	GORY						
Landi	ng G	ng Gear			General				-						
		Bending				Bend		Grain		ſ		Ovalized			Pressure/Forced
•		Centre N	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re	Ţ		Over/Under	tolerance		Temperature/Cure
	Cracks			Broken/Damaged		Inspecti	on incomplete	Ī		Part Incorre	ot .		Weld		
Crushed/Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled			
	П	Cuffs	•			Contamination		Mainte	· ·			Part Moved			•
	Heat Treat				Countersink		Mislabe	led	ļ		Positioned V	Vrong			
	Heat Treat Inspection Strip in Tube			. [Cut Too Short		Misread		İ	_	Power Loss/			Other	

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion ...

Drill Holes

Drawing

Finish Folio

DQA:	Date:	•
_		,

NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE
		•

										QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No NCR No	-				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	lr	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
				•	F	AUL	CATE	GORY				
Landing	Gear				General				_	,	_	-
	Bending Centre No Cracks Crushed/		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs		•	re ion Incomplete ions Incomplete/l	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	at _	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
ļ -	Cuffs	Cimpeu			Contamination	—-	Mainte	•		Part Moved	33116	J WI ONG STOCK I dired
 -	Heat Trea	at		<u> </u>	Countersink	\vdash	Mislabe		<u> </u>	Positioned V	Vrong	
<u> </u>	Inspection Strip in Tube				Cut Too Short		Misread			Power Loss/		Other
	Ripples in Bend			-	Drill Holes	\vdash	Offset	-	L	J 2003/		
Torque Waves in Extrusion Drawing				┥ ゜゜゜	\vdash		Calibration					
Turning Sequence			Finish	Out of Sequence				,				
Wave/Twist in Tube					Folio	-		Dimensions				······
11./FOD145/O14	4-/EORMS/Outlity Assurance/approved OA/NCRWO Pay G											

July-22-13 2:21:32 PM

Work Order ID: 104875

Parent Item: D2221

Parent Item Name: Basket Base Assembly

104875 *D2221*

Start Date: 7/22/13

Required Date: 8/05/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM

IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC

IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by EC IPP Rev:N 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N

10.06.29 added pressure wash DD verf:EC

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
_	*D2221-1 *D2221-1		Manufactured	_ №			100	Each	9.0000	**	1	/3-8	- ?-7	
					Location WA WA005	99744	<u>Loc (</u>	Oty 5 5 1	Loc Code	 	8	- - -		
/	D2221-5 *D2221-5* Rib		Manufactured	No	WA006	90106	100 i	3 3 Each	20.0000	**	2	[[]]	3-8-7	,
					Location WA004	88295 89193 94273	<u>Loc (</u>	20 16 2	Loc Code	_ _ _	(ZK)	- - -		
<u>-</u>	D2221-7 *D2221-7* Rib		Manufactured	No		:	100	Each	1.0000	1 **	1	CC /	13-8-	.7_
					Location WA004	•	<u>Loc (</u>	<u>) ty</u>	Loc Code		()	_		

												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE					,
											_	QA Closed:	Da	ate:	
Work Ord	er.					DISPOSITION		Į		AGAINST DI	EP:	ARTMENT,	PROCESS		
Part 1	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor re/Packaging Supplied		Engineering Quality Other
Root				Π	Descri	L ption of work order update	T^{-}	I Initial	Ac	ction	Τ	Sign &			
Cause		Date	Step	Qty	I '	or Non-conformance	Ct	nief Eng	Desc	cription	ļ	Date	Verification	on	QC Inspector
Doc/Data			<u> </u>	<u> </u>							T				
Equip/Tooling	Г	1													
Operator		1									1	ļ			
Material	Г	1													
Setup]													
Other]		ļ											
Process]	1												
Supplier					Į.										
Training			!	1											
Unapproved			<u> </u>			<u> </u>					\perp	_			
			_				FAUI	LT CATE	GORY		_				
Landi	ng (Gear				General	_	,		_	_				•
	L	Bending				Bend	L	Grain			_	Ovalized			Pressure/Forced
•	L	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	<u>_</u>	_ 0	Over/Under	tolerance		Temperature/Cure
	L	Cracks				Broken/Damaged		4 '	on Incomplete	_	┥`	Part Incorrec		-	Weld
	Crushed/Crimped			Burrs	L	Instruct	ions Incomplete,	/Unclear	Part Lost/Missing		Wrong Stock Pulled				
		Cuffs			_	Contamination	<u> </u>	Mainte	nance	L	_ P	Part Moved			
	Heat Treat				Countersink		Mislabe	led		P	Positioned W	/rong	_	•	
1	Inspection Strip in Tube				Cut Too Short		Misread	\$		P	Power Loss/S	Surge		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

July-22-13 2:21:32 PM

Work Order ID: 104875

104875

Parent Item:

D2221

D2221

Parent Item Name:

Basket Base Assembly

Start Date: 7/22/13

Required Date: 8/05/13

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured

100 Each

Loc Qty

3

3

20 2 23.0000

**

D2232-3

Basket Hinge

Location WA

97261 WA004

Loc Code

((13-8-7

D2235-1

Manufactured

18 100 Each

Loc Oty

16.0000

**

CC 13-8-7

Basket Rib

Location WA004

> 66895 85602 86051

96545

Loc Code

16

2

												DQA:	Da	ite:	
NCR:	/es	/ No				WORK ORDER NON-C	O	NFOR	MANCE / UP	DATE		•			•
		•							<u> </u>			QA Closed:	Da	ite:	
Work Orde	ar.	•				DISPOSITION				AGAINST	DE	PARTMENT	PROCESS		
Part I	Vo.					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing		-	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR I	No.					Work Order Update]		Large Fab	Composite	_	ŀ	Supplier	L	. L
Root					Descri	ption of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data															
Equip/Tooling				•	ļ										
Operator				,	ļ		ļ								
Material				·	İ										
Setup															
Other															
Process		'													
Supplier															
Training					ļ ·							1			
Unapproved			l	l	1										
						F/	AUL	T CATE	GORY			. <u> </u>			
Landi	ng (Gear				General		-				-			-
Bending			Bend		Grain			L	Ovalized		L	Pressure/Forced			
Centre Not Concentric to O/S			BOM/Route		Hardwa	re		L	Over/Under	tolerance	L	Temperature/Cure			
	Cracks					Broken/Damaged		Inspect	ion Incomplete		l	Part Incorrect			Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

July-22-13 2:21:33 PM

Work Order 1D: 104875

104875

Parent Item:

D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 7/22/13

Required Date: 8/05/13

Start Qty: 1.00

Required Oty: 1.00

D2581

Mounting Bracket

D2581

Location

WA004

81253 82506

83230 85452

87706

99837

D3442-1

D3825-041

Location

WA

98076

WA004

99654

Manufactured

Manufactured

No

Manufactured

Rib Assembly (Basket End)

Location

WA004

Each 115.0000

**

CC 13-8-7

Loc Code

115 24

Loc Oty

100

100

100

28 49 2

2

Each

23.0000

**

ll 13-8-7

Loc Qty Loc Code

3 20

Each

20

10.0000

**

CC 13-8-7

Loc Qty

Loc Code



July-22-13 2:21:33 PM

Shop Packet Print

Page 3

NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UPI	DATE			
				<u>.</u>	<u></u>	T	_				QA Closed:	Date	•
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
i viola	-					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1 '		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o.					Work Order Update			Large Fab	Composite		Supplier	
								<u> </u>					
Root	ĺ					ption of work order update		Initial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data	Ш		1								ļ]	
Equip/Tooling	Ш												
Operator	Щ												
Material	Щ												
Setup	Н		[
Other	\vdash]	i									
Process	Н												
Supplier	Н						1					1	
Training Unapproved	\vdash						ļ				1		
Unapproved	<u> </u>		L	L	<u>L</u>		AUI	T CATE	L GORY				1
Landi	ng G	ear			<u> </u>	General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	-	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	${oldsymbol{ o}}$	Cracks			<u> </u>	Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped	`		Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned \	Wrong	-
1	Inspection Strip in Tube		Cut Too Short		Misread	t		Power Loss	/Surge	Other			
	Ш	Ripples in	Bend			Drill Holes	Offset						
1	Torque Waves in Extrusion			Extrusio	n,	Drawing	\vdash	4	Calibration			<u> </u>	
	1	Turning Sequence				Finish	1	Out of 9	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-22-13 2:21:33 PM

Work Order ID: 104875

104875

Parent Item:

D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 7/22/13

Required Date: 8/05/13

Start Qty: 1.00

Required Qty: 1.00

D3826-041

Manufactured No 100

100

100

100

1

Each

Each

Each

6.0000

CC 13-8-7

D3826-041

Rib / Gusset Assembly

Location

WA004

Loc Oty

Loc Oty

Loc Code 8.0000

* *

**

**

11 13-8-7

D3827-041

Manufactured *D3827-041*

Rib Assembly (Inboard)

Location

W۸

Loc Code

5.0000

16 13-8-7

D3832-1

Mesh (Base)

D3832-1

Location

W۸

Loc Qty Loc Code

3 2

Loc Oty

15 3

12

Each

22.0000

**

CC 13-8-7.

D3833-I

Mesh (Base End Face)

Manufactured No

Manufactured

Location WA

99268

WA007 77521

81259 89208 98538

Loc Code

July-22-13 2:21:33 PM

Shop Packet Print

Page 4

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONF	ORM	ANCE / UP	DATE	QA Closed:	Date:	
Work Order:					DISPOSITION			. <u>-</u>	AGAINST DE	PARTMENT,	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	T	M: Thermo	kid-tube	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Init	tial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other												

Landing Gear General Bend Ovalized Pressure/Forced Bending Grain BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Burrs Cuffs Maintenance Part Moved Contamination Positioned Wrong Countersink Mislabeled Heat Treat Power Loss/Surge Other Inspection Strip in Tube Misread Cut Too Short Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Out of Sequence Turning Sequence Finish Folio Wave/Twist in Tube Outside Dimensions

FAULT CATEGORY

Process
Supplier
Training
Unapproved

D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY) NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

HΥ	GIY	P/N	DESCRIPTION
	х	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB - W
. 3	2	D2221-5	, RIB
; 4	1	D2221-7	RIS
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3825-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3933-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

SHOW k.j-, 1986 49 1.18 4.104

100

104.875 MC=

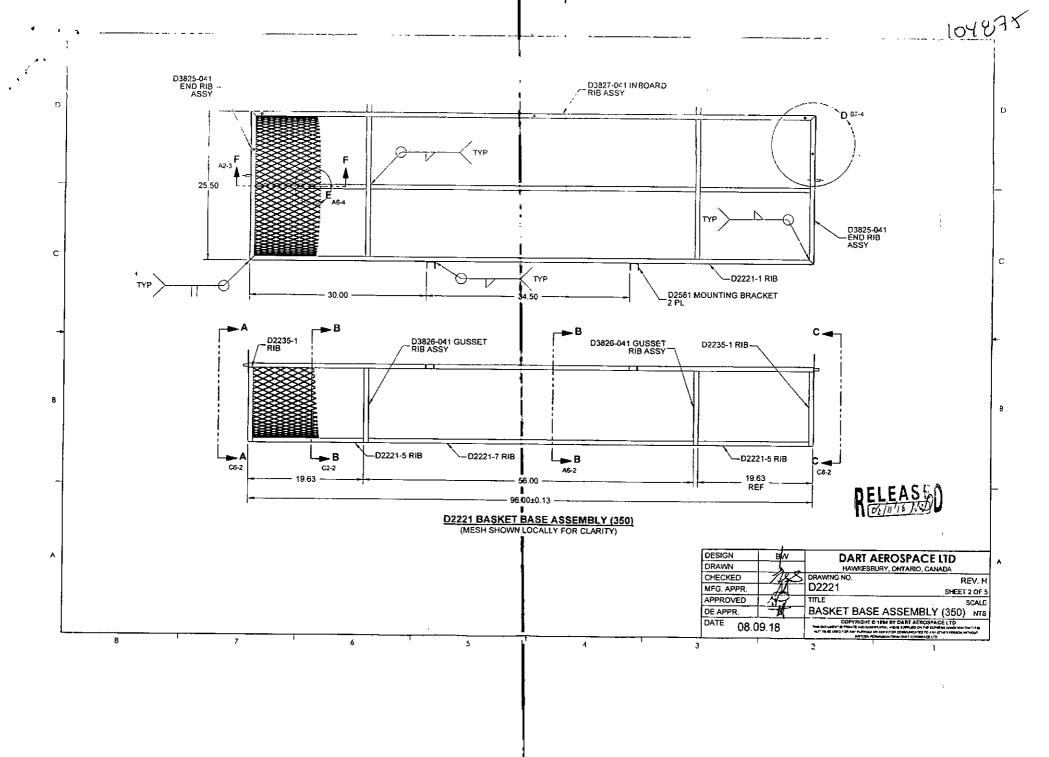
н	REVISEO PARTS LIST AND ADDED TIEM" COLUMN TO PARTS LIST [2N D3-1], REVISEO SECTIONS A.A. BA AND CC (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7- 4) ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR 02221-1/65-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN 08-3 AND ZN B4-3); D3625-041 REPLACES 02221-3/02327-3; 03826- 041 REPLACES 02235-102225; D3827-041 REPLACES 02221-1 ON INBOARD SIDE; ADDED 03832-1 AND 03833-1 REASON: SATISFY "LEAN MAND/FACTURING" PROGRAM.	мв	08.09 18
G	MATERIAL FOR -1, -3, -3, 8, 7 WAS 0.060 WALL: TOLERANCE FOR 96.00 DIM WAS -4-0.01 AND 56.00 DIM WAS AREF (ZN 85-2); 19.62 DIM WAS -4-ARD' DIMENSION IS NOW "REF" (ZN 84-2), NOTE 5 I RANSERED FROM SHI 1 TO SHI 2; SHI 2 MESH MATERIAL UPDATED: ORAWING TRANSFERED TO "B" FORMAT	AJS	09.06.16
۴	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH :	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	aw	96.06.21
С	SEPARATE BASKET AND LID	KH	95.11,21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	DART AEROSPACE LTD							
DRAWN	<u> </u>	HAWKESBURY, ONTARIO, CANADA							
CHECKED	. Vss	DRAWING NO. REV. H							
MFG. APPR.	\mathcal{M}_{\sim}	D2221 SHEET 1 OF 5							
APPROVED	. Nisk	TITLE SCALE							
DE APPR.	-4	BASKET BASE ASSEMBLY (350) NTS							
DATE 08.0	9 18	COPYRIGHT & 19M BY DART AEROSPACE LTD							

NCR: Y	es / No				WORK ORDER NON-C	CONFO	RMANCE / UI	PDATE	DQA:		:
					DISPOSITION			AGAINST DE	QA Closed: PARTMENT		
Work Orde	er:				Rework	1	Skid-tube	Crosstube	i '	Water Jet	Engineering
Part N	lo				Scrap Use-as-is	The	Machining moforming	Small Fab Finishing	-1	d. Eng. Coor. re/Packaging	Quality Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier]
Root	ŀ				ption of work order update	Initial		ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Des	cription	Date	Verification	QC Inspector
Doc/Data					•						
Equip/Tooling	_		.								
Operator	\dashv										
Material						1					
Setup	_					:					
Other Process	\dashv										
Supplier		1					ļ				
Training			}								
Unapproved											
	L	<u>.</u>			F	AULT CA	EGORY				
Landir	ng Gear				General				_		<u> </u>
	Bending				Bend	Grain	1		Ovalized		Pressure/Forced
	Centre N	ot Concei	ntric to (D/S	BOM/Route	Hard	vare	<u>_</u>	Over/Under	tolerance	Temperature/Cure
	Cracks			_	Broken/Damaged	\blacksquare	ction Incomplete	_	Part Incorre		Weld
	Crushed/	'Crimped			Burrs		ictions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
]	Cuffs			\vdash	Contamination	————	tenance	<u> </u>	Part Moved		
	Heat Trea				Countersink	\vdash	beled	<u></u>	Positioned V		ا م
	Inspectio	-	Tube	<u> </u>	Cut Too Short	Misre			Power Loss/	Surge	Other
	Ripples in		•	_	Drill Holes	Offse					
	Torque V			`	Drawing		f Calibration f Sequence				
	Turning S Wave/Tv			 	Finish Folio	\vdash	de Dimensions				

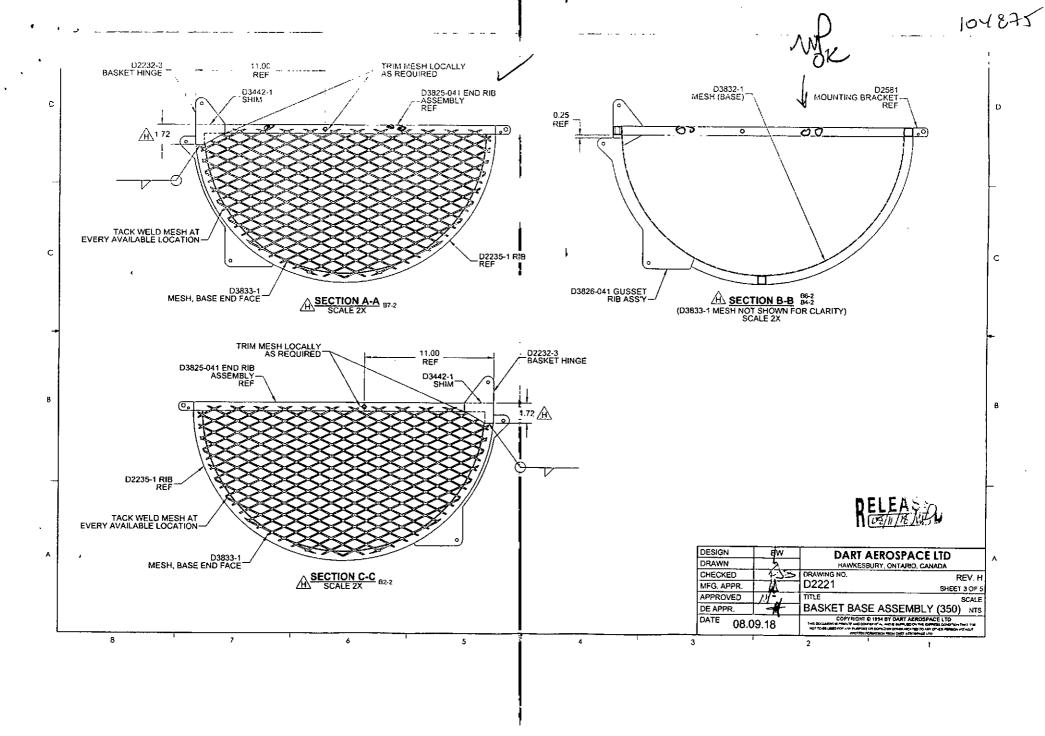
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube



			DQA:	Date
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

								QA Closed:	Da	ite:			
Work Orde	er:				DISPOSITION	-	PEPARTMENT/PROCESS						
Part N					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other	
Root					ption of work order update		Initial Action			Sign &			OC Incorporate in
Cause	Date	Step	Qty		or Non-conformance	Cn	ief Eng	Desc	cription	Date	Verificatio	" 	QC Inspector
Doc/Data											1	1	
Equip/Tooling													
Operator													
Material													
Setup								•					
Other [ļ							•			İ	
Process		İ									Ì		
Supplier		ŀ						1				i	
Training	\dashv											- 1	
Unapproved	<u> </u>	<u> </u>	1			<u></u>	T CATE	L		<u> </u>			
Landie	ng Gear				General	AUL			102	•			·
Landii	Bending				Bend		Grain		Г	Ovalized			Pressure/Forced
<u> </u>	Centre N	ot Conce	ntric to		BOM/Route	\vdash	Hardwa	ire	<u> </u>	Over/Under	tolerance	-	Temperature/Cure
	Cracks	or conce	THE CO	`,` -	Broken/Damaged	\vdash		ion Incomplete		Part Incorre		-	Weld
	Crushed/	Crimped			Burrs	\vdash		tions Incomplete	/Unclear	Part Lost/M		-	Wrong Stock Pulled
	Cuffs	J, P = =		<u> </u>	Contamination	┢		enance		Part Moved	Ü	ш	ŭ
	Heat Trea	at		-	Countersink	H	Mislabe	eled	ļ	Positioned \	Vrong		
	Inspectio		Tube		Cut Too Short	\vdash	Misrea		<u> </u>	Power Loss/	-		Other
	Ripples in				Drill Holes	-	Offset		L-	····	_		
	Torque V		Extrusio	n	Drawing	П	Out of	Calibration					
	Turning S				Finish	П	Out of:	Sequence					· · · · · · · · · · · · · · · · · · ·
	Waye/Tu				Teolio		Outside	Dimensions					



												DQA:	_ Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	cor	NFORM	MANCE / UP	DATE					•
		•							•			QA Closed:	Da	ate:	•
Work Ord	or.					DISPOSITION				AGAINST D	E	PARTMENT,	/PROCESS		
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
							_		• 🗆					_	
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	1	Initial nief Eng		tion ription		Sign & Date	Verificatio	วก	QC Inspector
Doc/Data			<u> </u>				1								
Equip/Tooling		•													
Operator															
Material			1												
Setup				•											
Other															:
Process				1			İ								
Supplier	L		ì				İ								
Training															
Unapproved						· · · · · · · · · · · · · · · · · · ·									<u> </u>
				****		<u> </u>	AUL	LT CATE	GORY						
Land	ing (1			_	General	_	7		r-		1			.
		Bending				Bend		Grain		 _		Ovalized		\vdash	Pressure/Forced
	$ldsymbol{le}}}}}}$	Centre N	ot Conce	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		-		Over/Under		\vdash	Temperature/Cure
		Cracks				Broken/Damaged	_	4	on Incomplete	<u> </u>		Part incorred		\vdash	Weld
		Crushed/	'Crimped			Burrs		┥	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte		L		Part Moved			
		Heat Tre	at			Countersink		Mislabe	eled	L		Positioned V	Vrong		•
1		Inspection	n Strip in	Tube		Cut Too Short	1	Misread	i			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

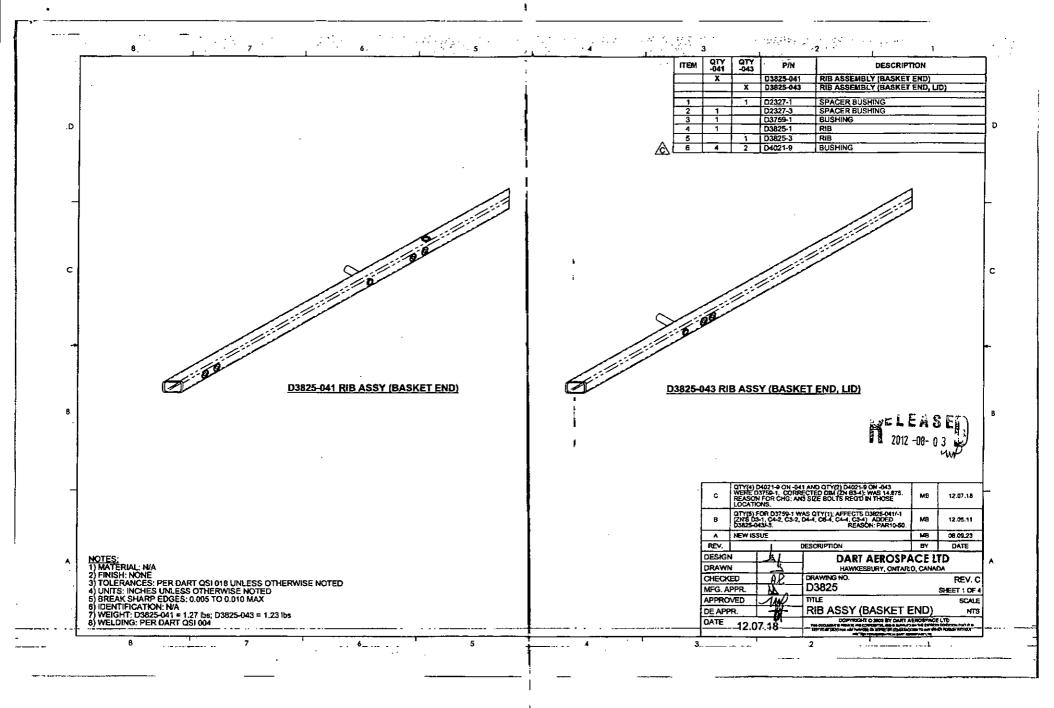
Torque Waves in Extrusion

Drill Holes

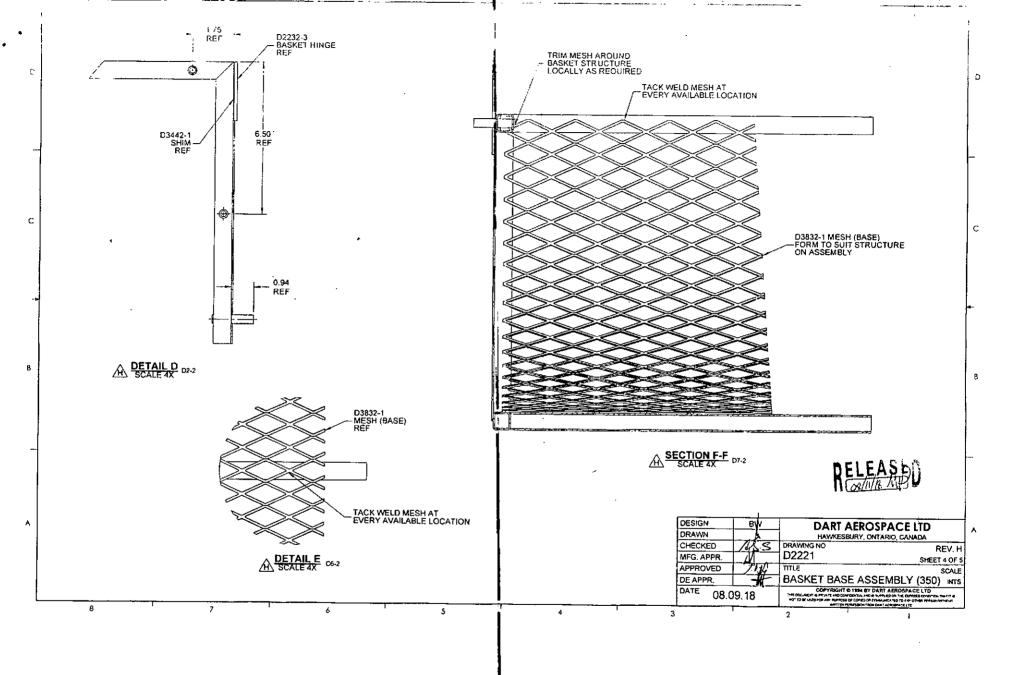
Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



		•		
			,	
			·	
			·	
	·			
•				

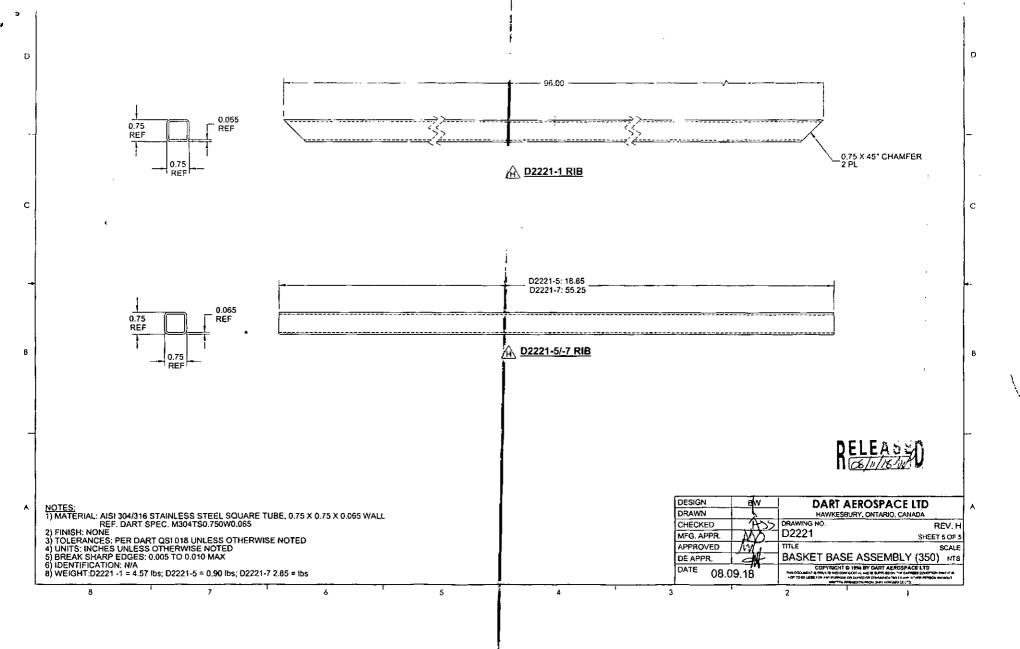


										DQA:	Date:		
NCR: Yes	/ No				WORK ORDER NON-	COI	VFORM	MANCE / U	PDATE	QA Closed:	Date:	,	4
Work Order:	_		•	. <u> </u>	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering	
Part No.					Scrap		ľ	Machining	Small Fab	Pro	od. Eng. Coor.	Quality	
					Use-as-is	Thermoforming Finishing		Finishing	Rec/Store/Packaging		Other		
NCR No.					Work Order Update			ermoforming Finishing Rec/Store/Packaging Other Large Fab Composite Supplier					
	T						l ,		-				
Root	{			Descri	ption of work order update	1	Initial	·	Action	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	De	scription	Date	Verification	QC Inspecto	r
Doc/Data		ļ											
Equip/Tooling													
Operator]										
Material	1	{											

FAULT CATEGORY Landing Gear General Bend Ovalized Pressure/Forced Bending Grain BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Part Incorrect Broken/Damaged Inspection Incomplete Weld Cracks Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Cuffs Contamination Maintenance Part Moved Countersink Mislabeled Positioned Wrong Heat Treat Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread Drill Holes Offset Ripples in Bend Out of Calibration Drawing Torque Waves in Extrusion Finish Out of Sequence Turning Sequence Folio Outside Dimensions

Wave/Twist in Tube

Setup Other Process Supplier Training Unapproved



*• -										•			4 a 3
					_						DQA:	Date:	
NCR: Ye	s / No		٠.		,	WORK ORDER NON-C	COI	NFORM	MANCE / UPI	DATE	QA Closed:	Date:	**
					T	DISPOSITION			· · · · · · · · · · · · · · · · · · ·	ACAINST	EPARTMENT	-	
Work Order	:					DISPOSITION			_	AGAINSTO			
Part No). 					Rework Scrap Use-as-is		t	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	—	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No)			<u>. </u>		Work Order Update	•		Large Fab	Composite]	Supplier	
Root				Desc	ripti	ion of work order update		Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or	Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Ooc/Data	-			,		,				•			
Operator	1			,				<i>;</i>	1				
Material		ĺ							· .				
ietup	7											!	:
Other	1												
rocess				i					-		-		
Supplier	\neg										i		
raining													
Jnapproved	7] _	_				•					
						F/	AUI	T CATE	GORY				
Landing	g Gear					General		_		_	_	<u></u>	•
	Bending			. [В	end		Grain		_	Ovalized		Pressure/Forced
L	Centre No	ot Conce	ntric to	o/s	В	OM/Route	匚	Hardwa	re		Over/Under		Temperature/Cure
	Cracks				B	roken/Damaged		Inspecti	on Incomplete	L	Part Incorre	—	Weld
	Crushed/	Crimped	•	. [B	urrs		Instruct	ions Incomplete/L	Inclear '	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs		•	[c	ontamination		Mainte	nance		Part Moved		
	Heat Trea	ı t		. [c	ountersink	L	Mislabe	led	Ĺ	Positioned \		•
	Inspection	n Strip in	Tube]c	ut Too Short	L	Misread	J		Power Loss/	Surge	Other
	Ripples in	Bend	_ 1g	: [rill Holes	_	Offset		·			
	Torque W	/aves in I	Extrusio	n [0	Prawing		Out of 0	Calibration				
	Turning S	equence	2		F	inish		Out of 9	Sequence				
	Wave/Tu	ist in Tu	he	[]F	olio		Outside	Dimensions				